



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3717

Job Sheet 203273



Part No: 646.3717

Job Qty: 20 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/19

Job Tracking No:

Due Date: 12/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEET 8 IPP REV:A 12.10.22 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Workcenter / Supplier	Lead Time	Sign-off
110	Waterjet - Flow - 1	20 pcs	12/12/19	12/12/19	0.17	0.55	Waterjet - Flow			02/19/11/26
120	QC 2	20 pcs	12/12/19	12/12/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			02/19/11/26
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			
							QC 2 - 66			
							QC 2 - 64			

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130 QC 8	20 pcs	12/12/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	NOV 27 2019
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Outsource - 4 - Anodize	20 pcs	12/12/19		ATG001-VC 8	2019-11-29
150 Packaging 2-1 - Receive - B4B	20 pcs	12/12/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DEC 12 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	

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DAS
40
9-89

					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
160 QC 6	20 pcs	12/12/19	0.00 0.00		QC 6 - 9	DAS
					QC 6 - 68	DEC 12 2019 68
					QC 6 - 61	9-89
					QC 6 - 40	
					QC 6 - 81	
190 Packaging 3-1 - Stock - B4B	20 pcs	12/12/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	

				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DEC 1 6 2019
				Packaging 3 - 36 - B4B	<i>Darab</i>
200	QC 21 - SA	20	12/12/19	QC 21 - SA - 21	<i>DAS</i>
	pcs		0.00 0.00	QC 21 - SA - 70	<i>21</i> DEC 1 6 2019
				QC 21 - SA - 53	<i>3-08</i>

Part Op 110 - (Waterjet - Flow) 1-Cut as per Dwg
Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
130 - (QC8- Inspect parts - second check)
140 - (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O 45268 ATG, black anodize and prime as per dwg 646.3717 Rev. A
150 - (Receive & Inspect for Damage & Mat'l Certs)
160 - QC6- All purchased or subcontracted products
190 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***
200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	.7200 sf (.036 ea)	110-Waterjet - Flow - 1	<i>5176525</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M6061T6S.063	1	363	0

CCK105

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	3.500Inches ± 0.030	3.530 3.470		
2	Doubler	1.500Inches ± 0.030	1.530 1.470		
3	Doubler	0.063Inches ± 0.010	0.073 0.053		

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NCR No. _____		Route update only			
Job: _____ Part No. _____		DEPARTMENT/PROCESS			
DISPOSITION		DEPARTMENT/PROCESS			
Rework Scrap Use-as-is		Cross tube Small Fab Finishing Skid-tube Machining Large Fab Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging Engineering Water Jet Supplier Quality			
Date : _____	Sequence #: _____	QTY Affected : _____			
Description Work Order Deviation		Disposition			
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	



Dart Aerospace Ltd.
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PURCHASE ORDER

POHB045268



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045268

PO Date: 11/29/19

Due Date: 12/16/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-12-05

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200659	646.3110	646.3100 Rev N/C	Channel : Various STC's Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3100	Firmed	-	12/16/19	20 pcs	0 pcs	20 pcs	\$11.70/pcs	\$234.00
2	202237	D5576-1	D5576 Rev A	Deflector, Upper, Cable Cutter : Various STC's Issue P/O: Black Anodize & Prime as per Dwg. D5576 Certification of Conformity is required.	Firmed	-	12/16/19	4 pcs	0 pcs	4 pcs	\$10.55/pcs	\$42.20
3	202492	647.1712	647.1700 Rev E	Gusset : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 647.1700 Rev. E	Firmed	-	12/9/19	23 pcs	0 pcs	23 pcs	\$13.70/pcs	\$315.10
Line Item Note **NEED BY DEC 9**												
4	203273	646.3717	646.3700 Rev A	Doubler : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O ATG, black anodize and prime as per dwg 646.3717 Rev. A	Firmed	-	12/16/19	24 pcs	0 pcs	24 pcs	\$7.30/pcs	\$175.20

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PURCHASE ORDER
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Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	202760	D5590-1	D5590 Rev A	Gusset, Inboard LH : Various STC's Issue P/O to ATG : 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5590 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed - XO		12/16/19	8 pcs	0 pcs	8 pcs	\$7.40/pcs	\$59.20
6	202761	D5590-2	D5590 Rev A	Gusset, Inboard RH : Various STC's Issue P/O: 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5590 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed - XO		12/16/19	8 pcs	0 pcs	8 pcs	\$7.40/pcs	\$59.20
7	196486	D5532-041	D5532 Rev A	Valve Cap Assembly : Various STC's Issue P/O: Blue Anodize as per Dwg D5532 BLUE ANODIZE PER MIL-A-8625F TYPE I or IB or IC or II or IIB CLASS 2	Firmed - XCO		12/9/19	20 pcs	0 pcs	20 pcs	\$8.55/pcs	\$171.00

Line Item Note ***NEED BY DEC 9**



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PURCHASE ORDER

POHB045268

**Items**

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	200189	D5579-1	D5579 Rev A	Center Clip, Cable Cutter : Various STC's Issue P/O: 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5579 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed	-	12/5/19	12 pcs	0 pcs	12 pcs	\$6.90/pcs	\$82.80
Line Item Note ** RUSH NEED BY DEC 5**												
Grand Total:												\$1,138.70

Order Notes**Procurement Quality Clauses**

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919189

Date: 10-Dec-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
20 ea	Part: 646.3110 Channel Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot# 5195271 Job: 26539 PO: POHB045268	Rev: NC	Expiry Date: 10/31/2020 Line: 1
24 ea	Part: 646.3717 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) Batch/Lot# 5195271 Job: 26542 PO: POHB045268	Rev: A	Expiry Date: 10/31/2020 Line: 4
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>DEC 10 2019</u> Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Made in Canada.			

RECEIVED

DEC 11 2019

DART AEROSPACE LTD.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List	
Number: 919189	Date: 10-Dec-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577 Fax: 613 632-1053 Ph: 613 632-9577 Fax: 613 632-1053

Terms		Ship Via
		ATG Delivery
Quantity	Description	
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
	Made in Canada.	